

Date: Tuesday, 17/02/2009 10:19:14 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ANGLE
<b>Job Number</b> : 45832	
<b>Estimate Number</b> : 13595	
<b>P.O. Number</b> :	<b>Part Number</b> : D38151
<b>This Issue</b> : 17/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3815 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 24/02/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.02.17</u>	
<b>Comment</b> : Est Rev:A 08-09-18 new issue DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S063	2024-T3 .063 sheet
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**Comment:** Qty.: 0.4859 sf(s)/Unit Total : 9.7188 sf(s)  
 2024-T3 .063 sheet  
 batch: 110337 B9-2-27

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3815  
 Dwg Rev: A B9-2-27  
 Prog Rev: A  
 \*\*\*\*grain direction along 4.30" \*\*\*\*  
 2-Deburr if necessary B9-2-27



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/02/27 421 counted

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 1- deburr if necessary  
 2- Bend as per Dwg D3815

ACCEPTABLE TO  
USE 20.14 THIS W/O ONLY 09.02.09

m-1 09/02/27



SB 09/03/03 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 17/02/2009 10:19:14 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 45832

Part Number: D38151

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



(-13)

Comment: INSPECT WORK TO CURRENT STEP

09/03/03 (20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(21)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

sub/BR

09/03/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-03

(22)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: 6-A

09/03/03 (23)

(24)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/04 (25)

Job Completion



MR  
09-03-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45835
<b>Description:</b> ANGLE		<b>Part Number:</b> D3815-1
<b>Inspection Dwg:</b> D3815-1, <b>Rev:</b> A		<b>Page 1 of 1</b>

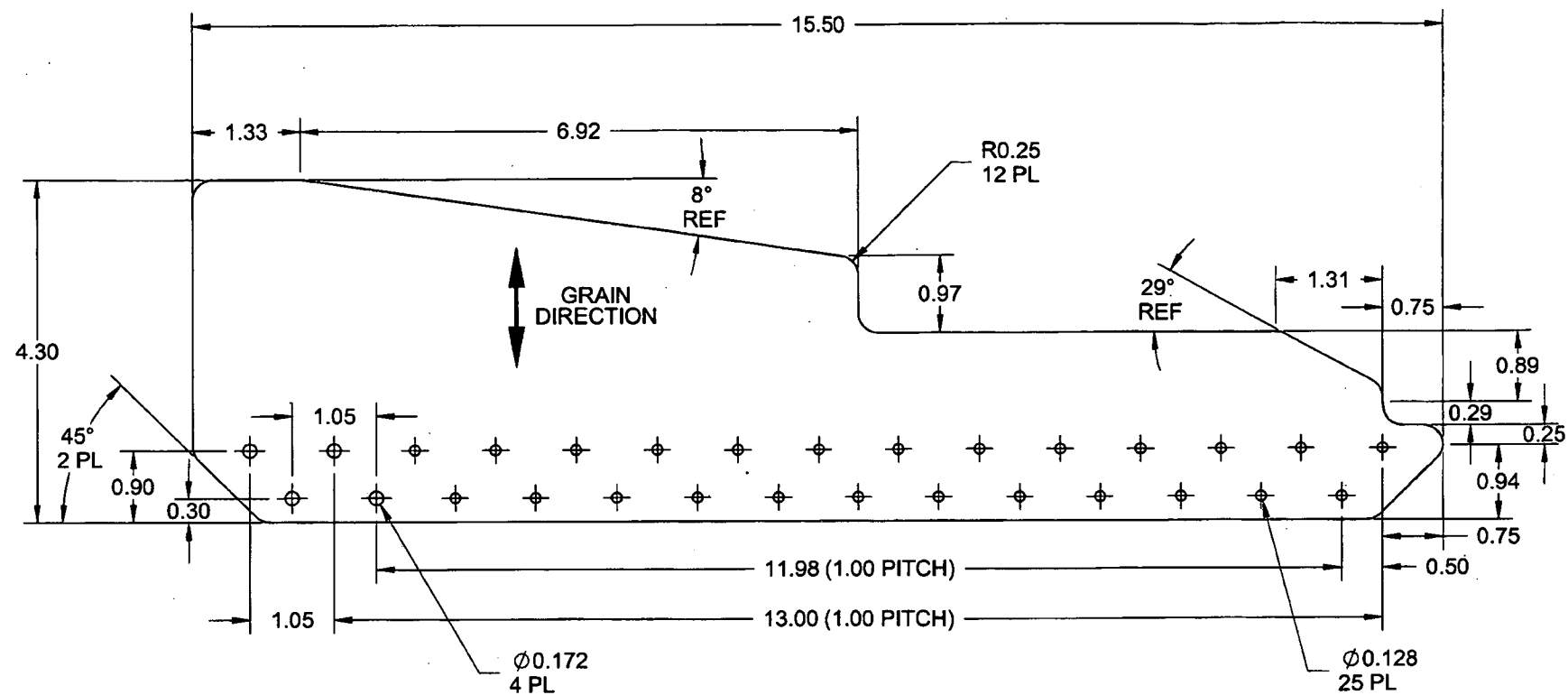
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+0.005 - .001	.131	✓			
Ø .172	+0.005 - .001	.175	✓			
.30	+/- .030	.309	✓			
.90	+/- .030	.908	✓			
1.05	+/- .030	1.054	✓			
1.05	+/- .030	1.054	✓			
4.30	+/- .030	4.300	✓			
1.33	+/- .030	1.335	✓			
11.98	+/- .030	11.998	✓			
1.00	+/- .030	1.000	✓			
13.00	+/- .030	13.015	✓			
1.00	+/- .030	1.000	✓			
.50	+/- .030	.502	✓			
.75	+/- .030	.747	✓			
.94	+/- .030	.941	✓			
.25	+/- .030	.244	✓			
.29	+/- .030	.293	✓			
.89	+/- .030	.888	✓			
.75	+/- .030	.762	✓			
<del>4.30</del>	+/- .030					
15.50	+/- .030	15.50	✓			
.063	+/- .010	.062	✓			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b> 12
<b>Date:</b> 9-2-27	<b>Date:</b> 09/02/27	<b>Date:</b> 19







Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



# **D3815-1F FLAT PATTERN**

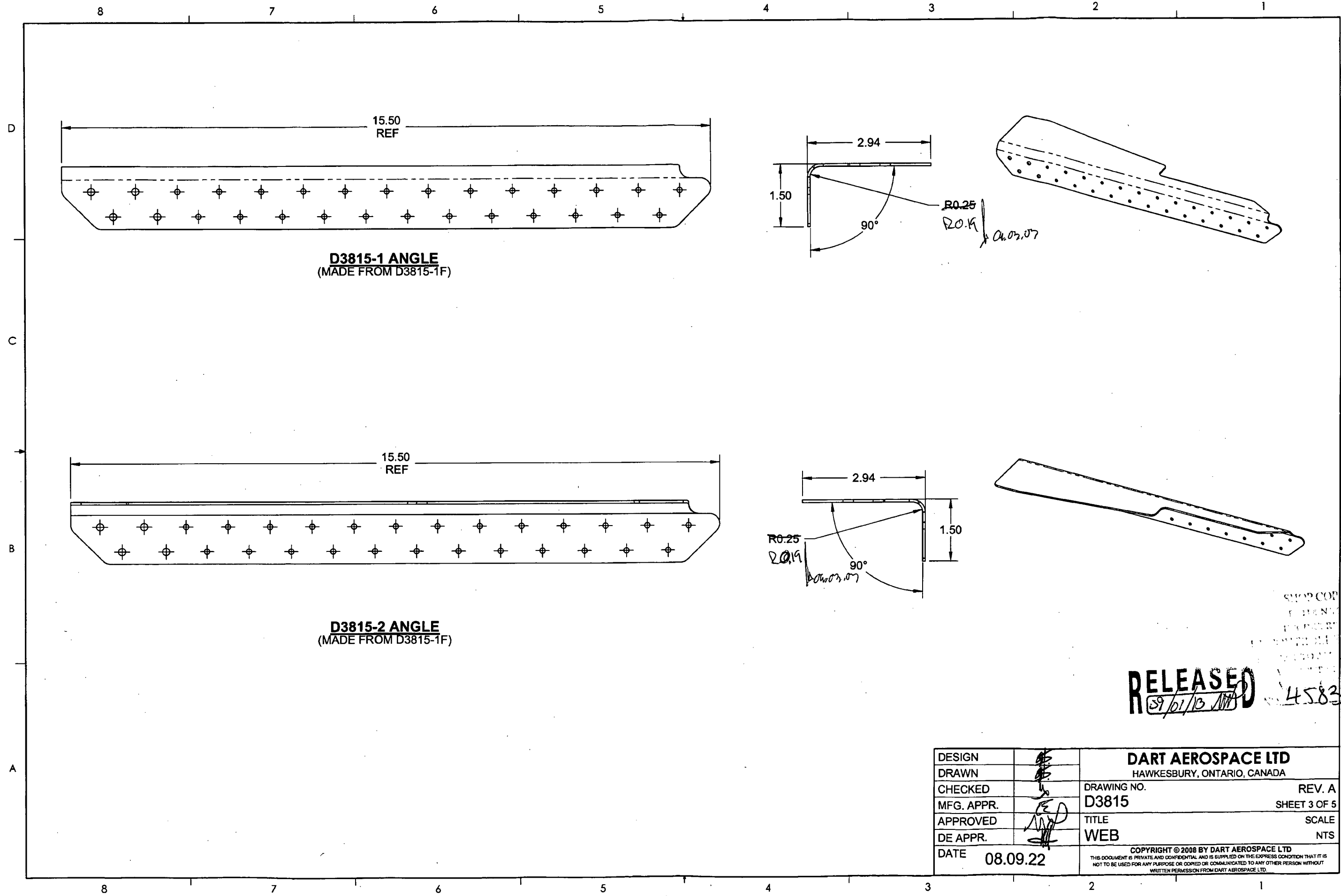
## **NOTES:**

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: N/A
- 5) WEIGHT: 0.29 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3815	SHEET 2 OF 5
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